

Work Order ID 129603

February-19-15 9:04:14 AM

129603

Page 1

Item ID: D6103-003 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Round Billet, Aluminum
 Start Date: 2/19/15 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 3/05/15 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: V Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6103	Rev B

100	PURCHASING	0.00							
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100

Purchasing CX 15/02/19 30

Purchasing Memo 0.00

Issue P/O: 27489 a) Description: Alluminum round billet b)
 Ø3.500" x 12.500" long c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T7351 (QQ-A-225/9) Material certification required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
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110

Packaging 303 FEB 26 2015 DAS

Packaging Memo 0.00 06

Ensure material certification is attached

9-89

120	QC6- Inspect dimensions to drawing	0.00							
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120

QC 33 6 DAS

Quality Control Memo 0.00 15/02/28

Work Order ID 129603

February-19-15 9:04:14 AM

129603

Page 2

Item ID: D6103-003 Accept *N19000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Round Billet, Aluminum
 Start Date: 2/19/15 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 3/05/15 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Identify as per dwg & Stock Location: MAT 43 0.00

130

Packaging

Memo

0.00

Packaging

33

0

DAS

14

9-89

15/02/28

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ

15-03-02

Handwritten signature and date: 15-3-2

Picklist Print

February-19-15 9:04:14 AM

Page 1

Work Order ID: 129603

129603

Parent Item: D6103-003

D6103-003

Parent Item Name: Round Billet, Aluminum

Start Date: 2/19/15

Required Date: 3/05/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 06-02-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6103-003P

Purchased

No

110

Each

0.0000

1

30

D6103-003P

**

Round Alum Billet

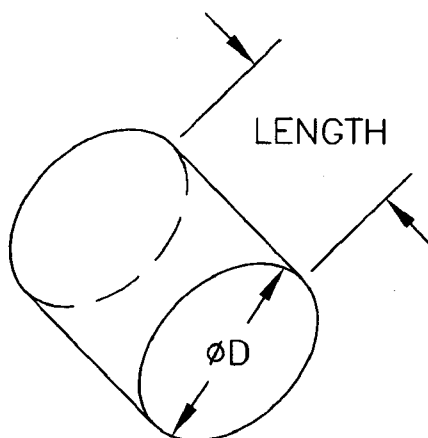
DAS
06
9-89



DESIGN P41	DRAWN BY P41	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07 [Signature]



WLO 129603

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2513190

Ship From: A. M. Castle & Co. (Canada) Inc. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 24-FEB-2015	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 2513190-2	

Shipment Details	Final Destination Branch - MON
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Order No 3751721	Line No 1	Item No 8808.MO	Description 3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS QQ-A-225/9
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Purchase Order No 27489	Part Number YOUR ITEM NUMBER: D6103-003	Ordered Qty 33.00 PCS	Invoice Qty 33.00 PCS
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Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S FORWARD COPY OF P/S TO COLLEEN (MONTREAL) Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 119966900	Mill KAISER ALUMINUM	Heat Number 	Mech Id	PCS 33 15/02/26 SK	Width (IN)	Length (IN)	Shipped Qty(LBS) 400.1373
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These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 24-FEB-2015 11:29:50 AM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

Reviewed by Authorized Castle Metals Representative:		Date:	Name:
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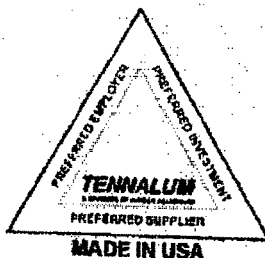


24 FEB. 2015

[Handwritten signature]

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
309 Industrial Drive
Jackson, TN 38301
731-423-2811



CERTIFIED TEST REPORT
<http://Online.KaiserAluminum.com>

CUSTOMER PO NUMBER 310060-1		CUSTOMER PART NUMBER 8808		PRODUCT DESCRIPTION Cold Finished Round	
KAISER ORDER NUMBER 700732	LINE ITEM 1	SHIP DATE 11/03/2014	ALLOY 7075	TEMPER T7351	
WEIGHT SHIPPED 4222 lbs.	QUANTITY 30 pcs.	B/L NUMBER 37520	DIAM/DIA/THICKS 3.500 in.	WIDTH 0.000 in.	LENGTH 144.0 in.
SHIP TO A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA			A M Castle & Co 1420 Kensington Road Suite 220 Oak Brook, IL 60523 USA		

DAS
14
9-89 1502/28

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20189333	70.6	59.3	15.0	39.3

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.13	0.29	1.4	0.04	2.8	0.19	5.8	0.03			20189333
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.55	0.15	
Min			1.2		2.1	0.18	5.1				

Specifications

Standard: ISO 9001, ASTM B211-12, AMS 4124E, AMS-QQ-A-225/9A Non-Standard: A97075-11-R13

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

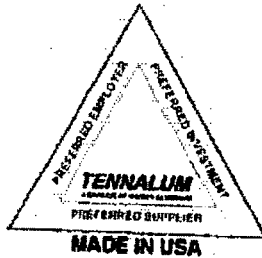
Plant Serial: 209932

Kaiser Order Number: 700732

Line Item: 1

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
309 Industrial Drive
Jackson, TN 38301
731-423-2811



CERTIFIED TEST REPORT
<http://Online.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. AS9100C:2009 The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material complies with FAR BAA (FAR 52.225-1, Buy American Act-Supplies), DFARS BAA (DFARS 252.225-7001 Buy American Act & Bal of Payments Prog), and FAR TAA (FAR 52.225-5 Trade Agreements). No weld repair. This material is RoHS 2 compliant.

DAS
14
9-89 15/02/28

Castle Metals FR
HEAT NUMBER 20189333
MECHANICAL ID
ITEM CODE 8808
LOT NUMBER
PO NUMBER 310060
RECEIPT DATE 11-6-14
SUPPLIER Kaiser
SPECIFICATION
LCS F
COMMENT
APPROVED

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

BON DE CONNAISSANCE NOMINATIF ABRÉGÉ - ORIGINAL - NON NEGOCIABLE STRAIGHT BILL OF LADING - SHORT FORM - ORIGINAL - NOT NEGOTIABLE REÇU, Sujet aux classifications et tarifs en vigueur à la date d'émission du présent bon de connaissance RECEIVED, Subject to the classification and tariffs in effect on the date of issue of this Bill of Lading Le bien décrit plus bas, en bon état apparent, exception faite comme noté (le contenu et la condition du contenu de l'emballage inconnus), marqué, consigné et destiné comme indiqué ci-après, que le dit transporteur (le mot « transporteur » signifiant dans ce contrat toute personne ou société en possession du bien en vertu de ce contrat) accepte de le transporter à l'endroit habituel de livraison de ladite destination, si sur sa route, ou sinon de la livrer à un autre transporteur en route vers ladite destination. Il est mutuellement accepté, par chacun des transporteurs de toute ou n'importe quel dit bien, en totalité ou en partie de la route à destination, et par chaque partie intéressée par la totalité ou n'importe quelle partie du bien à n'importe quel moment, que chaque service à être exécuté tel que décrit ci-après est sujet à toutes les modalités et conditions générales du bon de connaissance nominatif « Uniform Domestic Straight Bill of Lading » présenté (1) dans la Classification uniforme de transport en vigueur à la date des présentes, s'il s'agit d'une expédition par voie ferroviaire ou par voie marine, ou (2) dans la classification ou le tarif applicable au transporteur motorisé s'il s'agit d'une expédition par véhicule motorisé. The property described below, in apparent good order, except as noted (contents and condition of contents of packages unknown), marked, consigned, and destined as indicated below, which said carrier (the word carrier being understood throughout this contract as meaning any person or corporation in possession of the property under the contract) agrees to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any said property over all or any portion of said route to destination, and as to each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Bill of Lading set forth (1) in Uniform Freight Classification in effect on the date hereof, if this is a rail or rail-water shipment, or (2) in the applicable motor carrier classification or tariff this is a motor carrier shipment.		No du livreur / Shipper No.: 2513190-2 De - A / FROM AT: A. M. Castle & Co. (Canada) Inc. 835-SELKIRK AVENUE POINTE CLAIRE QC H9R 3S2 CAN d expédition / Ship Date: 24-FEB-2015 MANITOULIN TRANSPORT 1-800-265-1485  20954945
Consigné à / Consigned To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7 CAN	Directives de livraison / Delivery instructions: TOUS LES CHARGEMENT DOIVENT ÊTRE COUVERT. LA LISTE D'EMBALAGE DE LIVRAISON ET LES RAPPORTS DE TEST OU CONSIGNATAIRES REFUSERONT. ALL LOADS MUST BE TARPED. DELIVER PACKING LIST AND TEST REPORTS OR CONSIGNEE WILL REFUSE.	Modalités de paiement / Payment Terms: Prepaid REMETTRE LES FACTURES DE TRANSPORT À / REMIT FREIGHT INVOICES TO: RayTrans Management, Inc. PO Box 1210 Washington PA 15301
Nom du Transporteur / Carrier Name: MANITOULIN	Couverture d'assurance additionnelle / Additional Insurance Coverage: La valeur acceptée ou déclarée de la propriété ci bas spécifiée par le transporteur n'excède pas : The agreed or declare value for the property is hereby specifically stated by the shipper to be not exceeding: _____ par / per _____	

Détail de livraison / Shipment Breakdown:

Quantité / Quantity	Emballage / Packaging	Classe / Class	Commodity
1	BOX	FAK_50	Metal Product
1	BUNDLE	FAK_50	Metal Product

Poids du Chargement / Shipment Weights:

Produit / Product	437 LBS
Dunnage	25 LBS
Gross	462 LBS

ORDER DETAIL:

Bon de commande du client / Customer PO	No de commande du client / Sales Order No.	No de ligne / Line No.	No. d'Item Castle / Castle Item No.	Quantité livrée / Quantity Shipped	Castle UOM
27489	3751721	1	3751721*1*1	33	PCS
27509	3748709	2	14966	37	LBS

Sujet à la section 7 des Conditions générales du Bon de connaissance applicable. Si cette expédition est livrée au consignataire sans recourir à l'expéditeur, l'expéditeur doit signer les déclarations suivantes. Subject to Section 7 of Conditions of applicable bill of Lading. If this shipment is to be delivered to the consignee without recourse to the consignor, the consignor shall sign the following statements. Le transporteur ne doit pas livrer ce chargement sans avoir acquitté les frais de transport et les charges légales. The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges. CETTE EXPÉDITION DOIT ÊTRE REÇUE ET TRANSPORTÉE CONFORMÉMENT À TOUTES LES MODALITÉS ET CONDITIONS GÉNÉRALES DU BON DE CONNAISSANCE COMPAGNIES DE NAVIGATION. THIS SHIPMENT IS TO BE TENDER RECEIVED AND TO BE CARRIED SUBJECT TO ALL TERMS AND CONDITIONS OF THE STEAMSHIP COMPANIES CURRENT FORM BILL OF LADING CE DOCUMENT CERTIFIE QUE LES ARTICLES MENTIONNÉS CI-DESSUS SONT PROPREMENT CLASSIFIÉS, DÉCRITS, EMBALLÉS, MARQUÉS ET IDENTIFIÉS, ET SONT EN ÉTAT D'ÊTRE TRANSPORTÉS CONFORMÉMENT AUX RÈGLEMENTS DU MINISTÈRE DES TRANSPORTS. THIS IS TO CERTIFY THAT THE ABOVE NAMED ARTICLES ARE PROPERLY CLASSIFIED, DESCRIBED, PACKAGED, MARKED AND LABELED, AND ARE IN PROPER CONDITION FOR TRANSPORTATION ACCORDING TO THE APPLICABLE REGULATIONS OF THE DEPARTMENT OF TRANSPORTATION.	Si l'expédition se déplace entre deux ports par un transporteur par voie maritime, la loi exige que le bon de connaissance stipule s'il s'agit « du poids du transporteur ou de l'expéditeur ». NOTE : Là où la charge est en fonction de la valeur, les expéditeurs doivent déclarer spécifiquement par écrit la valeur du bien acceptée ou déclarée. If the shipment moves between two ports by a carrier by water, the law requires that the bill of lading shall state whether it is "carrier's or shipper's weight." NOTE: Where the rate is dependent on value, the shippers are required to state specifically in writing the agreed or declared value of the property. L'expéditeur déclare spécifiquement que la valeur acceptée ou déclarée du bien ne dépasse pas. The agreed or declared value of the property is hereby specifically stated by the shipper to be not exceeding Le client est responsable de tous les documents d'expédition et de se conformer à toutes les lois canadiennes et américaines incluant, mais sans s'y limiter, les lois et règlements américains et canadiens relatifs à l'exportation. Customer is responsible for all shipping documents and compliance with United States and Canadian laws, including but not limited to U.S. and Canadian Export laws and regulations.
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27489**

Purchase Order Date 2/19/2015

PO Print Date 2/19/2015

Page Number 1 of 2

Order From : VC-MET001
METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - C/O 910720
P.O. BOX 4090 STN A
TORONTO, ON M5W OE9
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 694 9575	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	CAD
Ship Via:	VENDOR'S TRUCK	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6103-003P AS PER DWG D6103 REV. B B129603 MATERIAL: 7075-T7351 AS PER QQ-A-225/9 SIZE: 3.500" X 12.500" LONG	Round Alum Billet	2/25/2015 Yes 2/25/2015		30.00 Each <i>130126</i> <i>SD</i>	\$75.75	\$2,272.50

Line Total: \$2,272.50

2	71401-45	PROCUREMENT QUALITY CLAUSES	2/25/2015 No 2/25/2015		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 RIGHT OF ENTRY A012 CHEMICAL AND PHYSICAL TEST REPORTS A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Note:

2/19/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27489

Purchase Order Date 2/19/2015

PO Print Date 2/19/2015

Page Number 2 of 2

Order From :

VC-MET001

Ship To : DART AEROSPACE LTD

METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - C/O 910720
P.O. BOX 4090 STN A
TORONTO, ON M5W OE9
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

514 694 9575

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Line Total: \$0.00

PO Total: \$2,272.50

u
CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 2/19/2015

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 8720 D6103-003
 RECEIVED BY: _____
 DATE: 15/02/26
 P/O#: 27489
 QUANTITY ORDERED: 30
 THICKNESS ORDERED: 03.500 X 12.50
 SHEET SIZE: _____
 MATERIAL CERT RECEIVED: yes
 QUANTITY RECEIVED: 30
 THICKNESS RECEIVED: 03.50 X 12.50
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
INCORRECT FINISH	Y ☒ N	
CORROSION	Y ☒ N	
INCORRECT GRAIN DIRECTION	Y ☒ N	
INCORRECT MATERIAL	Y ☒ N	
INCORRECT THICKNESS	Y ☒ N	
PHOTO REQUIRED	Y ☒ N	
CORRECT MATERIAL	☒ Y N	
CORRECT REF # TO LINK CERT	☒ Y N	
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>[Signature]</u>	BY: _____
DATE: <u>15/02/28</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASES ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER